

**Work Order ID 48669A**

July 2, 2009 8:39:54 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2221	Rev H								
100	Large Fab	0.00							
	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221!J2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221!J3- tack weld mesh on basket as per dwg D2221!J A/R ER316 S.S.								
Large Fab	Rod Batch: <u>4109213</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
QC	Cp0907-07								
Quality Control	D-0907-07								
120	QC6- Inspect dimensions to drawing	0.00							
	Memo	0.00							
QC	=7 80907/07 80								
Quality Control									

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Page 2

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Approvals: Process Plan:

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Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



## Sequence ID/ Work Center ID

### Operation Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powder Coating

#### Memo

0.00

1- Plug holes prior to 10:30AM 2- 1<sup>ST</sup> COAT: START  
TIME: 10:40AM OVEN TEMPERATURE:  
11:00AM FINISH TIME:  
11:30AM 2<sup>ND</sup> COAT if necessary\*\*\*\*\* 2<sup>ND</sup> COAT: START

140



QC3- Inspect Part Finish

0.00

09-07-8

QC

#### Memo

0.00

Quality Control

150



QC21- Final Inspection - Work Order Release

0.00

QC

#### Memo

0.00

Quality Control

09/07/09 HJ

09.07.09

# Picklist Print

July 2, 2009 8:39:53 AM

Page 1 -

Work Order ID: 48669A



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/15/09

Required Date: 8/03/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3826-041RevB		Manufactured	No			100	Each	6.0000	2.0000	✓		

Rib / Gusset Assembly



## Warehouse

### Location

#### Main Warehouse

ST	6	_____
48644	6	_____

Date: Friday, 19/06/2009 11:22:41 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 48669A			Part Number	: D2221		
Estimate Number	: 10189			Drawing Number	: D2221 REV H		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/06/2009 S.O. No. :			Drawing Revision	: H		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 26/06/2009 Qty: 1 Um: Each		
Previous Run	: 48667A						
Written By	:						
Checked & Approved By	: <u>MF 09-06-19</u>						
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC Est Rev:M 08-12-02 revH as per dwg DD verified by:						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
✓ 1.0	D22211	Rib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B48318</u>	SAN 09-06-19 AD-09
✓ 2.0	D22215	Rib	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: <u>B48390</u>	SAN 09-06-19
✓ 3.0	D22217	Pib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B48201</u>	SAN 09-06-19
✓ 4.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Hinge batch: <u>B47263</u>	SAN 09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/06/2009 11:22:41 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48669A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

✓ 5.0 D22351 Basket Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Rib

batch: B48451

SAD 09-06-19

✓ 6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

batch: B48428

SAD 09-06-19

✓ 7.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B47074

SAD 09-06-19

✓ 8.0 D3825041 Rib Assembly (Basket End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib Assembly (Basket End)

batch: B48430

SAD 09-06-19

✓ 9.0 D3826041 Rib / Gusset Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib / Gusset Assembly

batch: B48644

PD 09-06-23

✓ 10.0 D3827041 Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B48100

SAD 09-06-19

✓ 11.0 D38331 Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Base End Face)

batch: B48322 48217

SAD 09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

Date: Friday, 19/06/2009 11:22:41 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48669A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

✓ 12.0 D38321 Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: B48332

SAD 09-06-19 0

✓ 13.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M108160

10/09/07/07

✓ 14.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/09/07/07

AD

✓ 15.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

10/09/07/07

10/09/07/07

✓ 16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

10/11/07/07

✓ 1- Plug holes prior to powder coating

✓ 2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: 10:30AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:00AM

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: 11:00AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:30AM

10/09/07/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

Date: Friday, 19/06/2009 11:22:41 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48669A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0  QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BK 09-07-8 ①*

18.0  QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

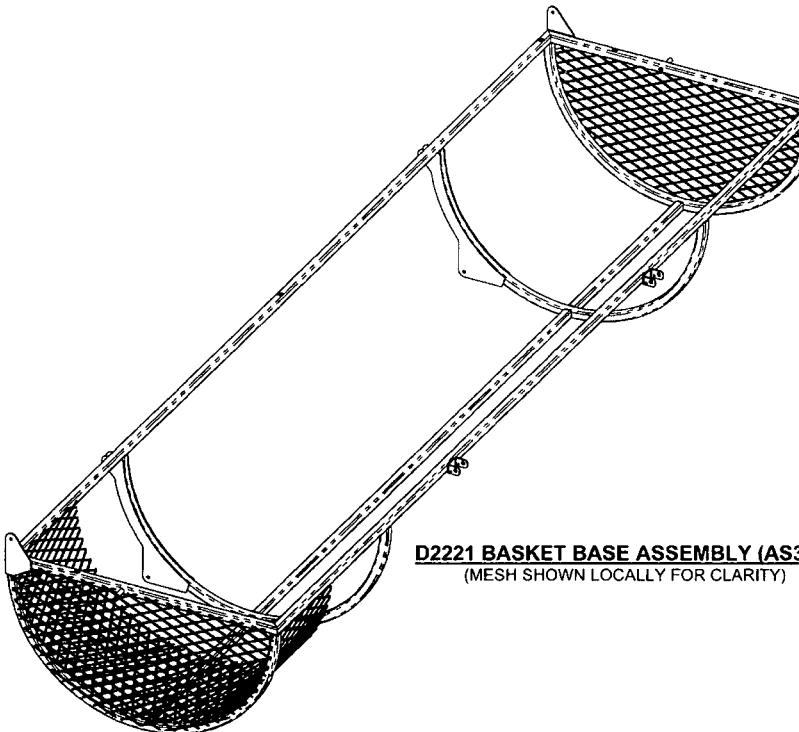
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NOTE: Date & initial all entries

	8	7	6	5	4	3	2	1
D								
C								
B								
A								



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

*REV D  
08/11/94*

*14866 DK*

ITEM	QTY	P/N	DESCRIPTION	
			1	X
1	X	D2221	<b>BASKET BASE ASSEMBLY (AS350)</b>	
2	1	D2221-1	RIB	
3	2	D2221-5	RIB	
4	1	D2221-7	RIB	
5	2	D2232-3	BASKET HINGE	
6	2	D2235-1	RIB	
7	2	D2581	MOUNTING BRACKET	
8	2	D3442-1	SHIM	
9	2	D3825-041	RIB ASSY (BASKET END)	
10	2	D3826-041	RIB/GUSSET ASSY	
11	1	D3827-041	RIB ASSY (INBOARD)	
12	2	D3833-1	MESH, BASE END FACE	
13	1	D3832-1	MESH (BASE)	

H	<p>REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST. D2221 REVISED SECTIONS A-B AND C-C (ZN B-3, C-4 AND A-3); REVISED SECTION A-B AND C-C (ZN B-3, C-4 AND A-3); REVISED SECTION D-B AND B7-C (ADDED SECTION E (ZN A-6)); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.</p>	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "+0.01" DIMENSION IS NOW REF (ZN B4-2). NOTE 3 TRANSFERRED FROM SHT 1 TO SHEET 5. MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	DRAWN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	A			
CHECKED	MJS	DRAWING NO. D2221 REV. H		
MFG. APPR.	MJS	SHEET 1 OF 5		
APPROVED	MJS	TITLE SCALE		
DE APPR.	MJS	BASKET BASE ASSEMBLY (350) NTS		
DATE	08.09.18			

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

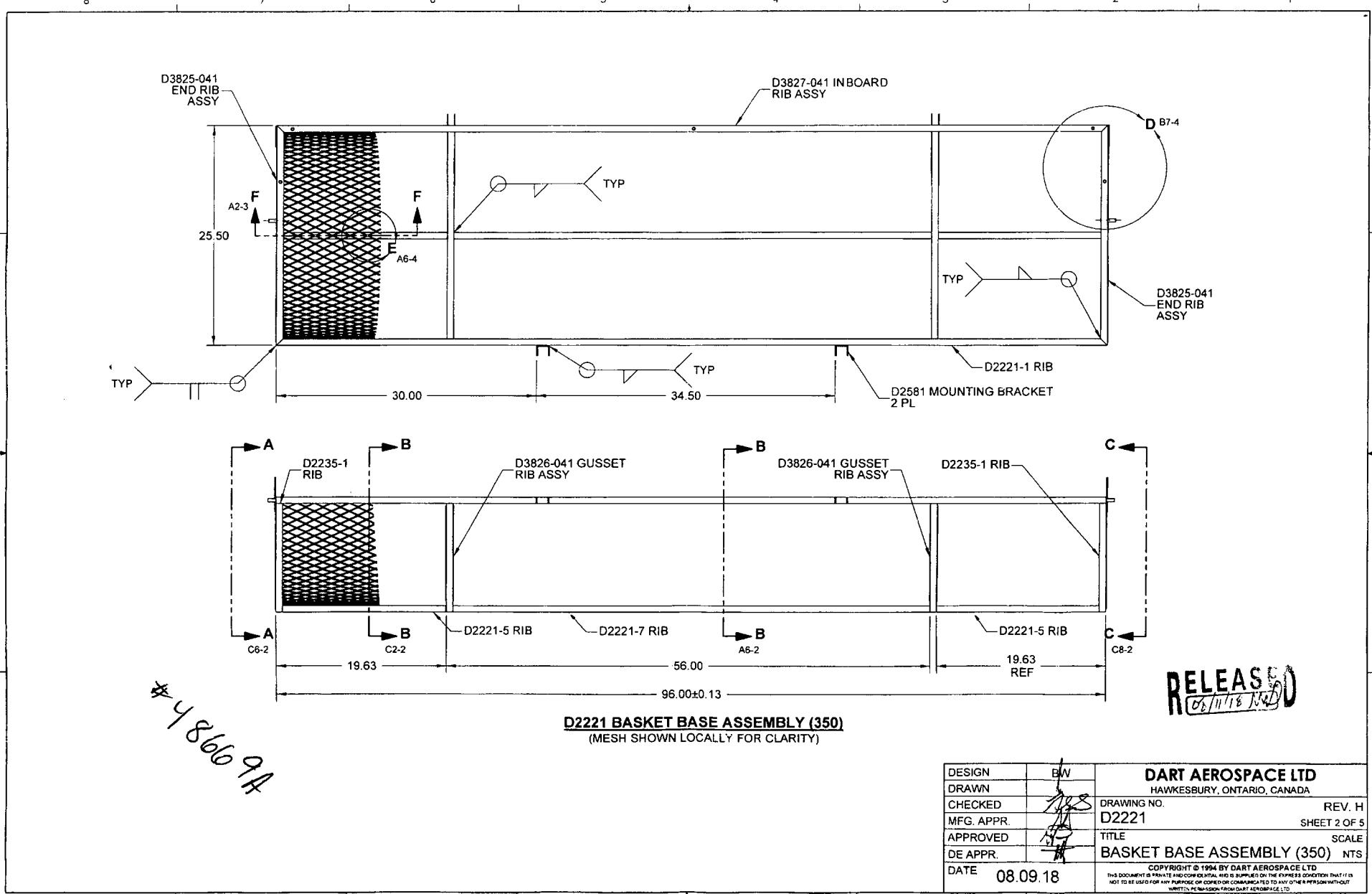
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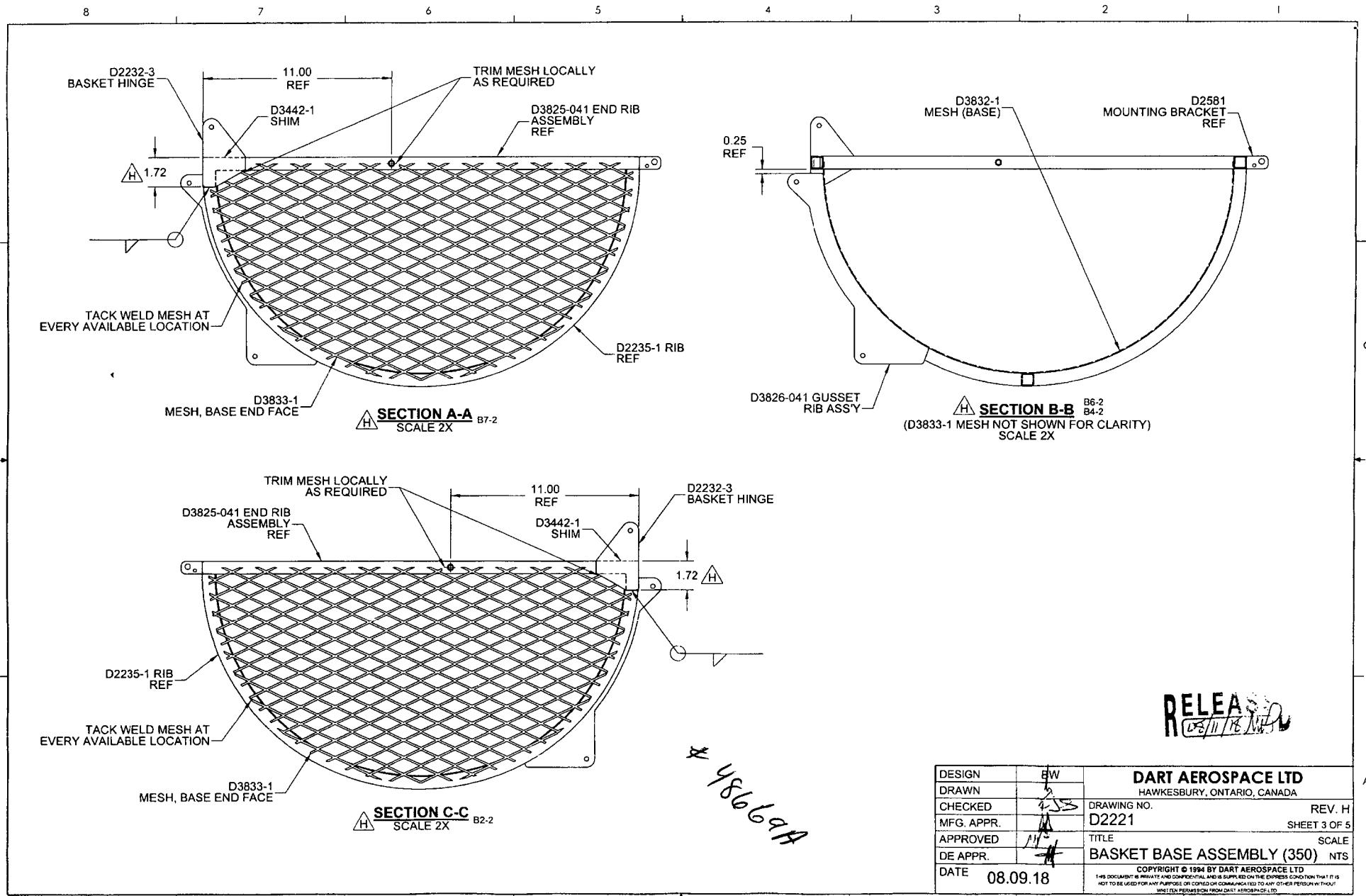
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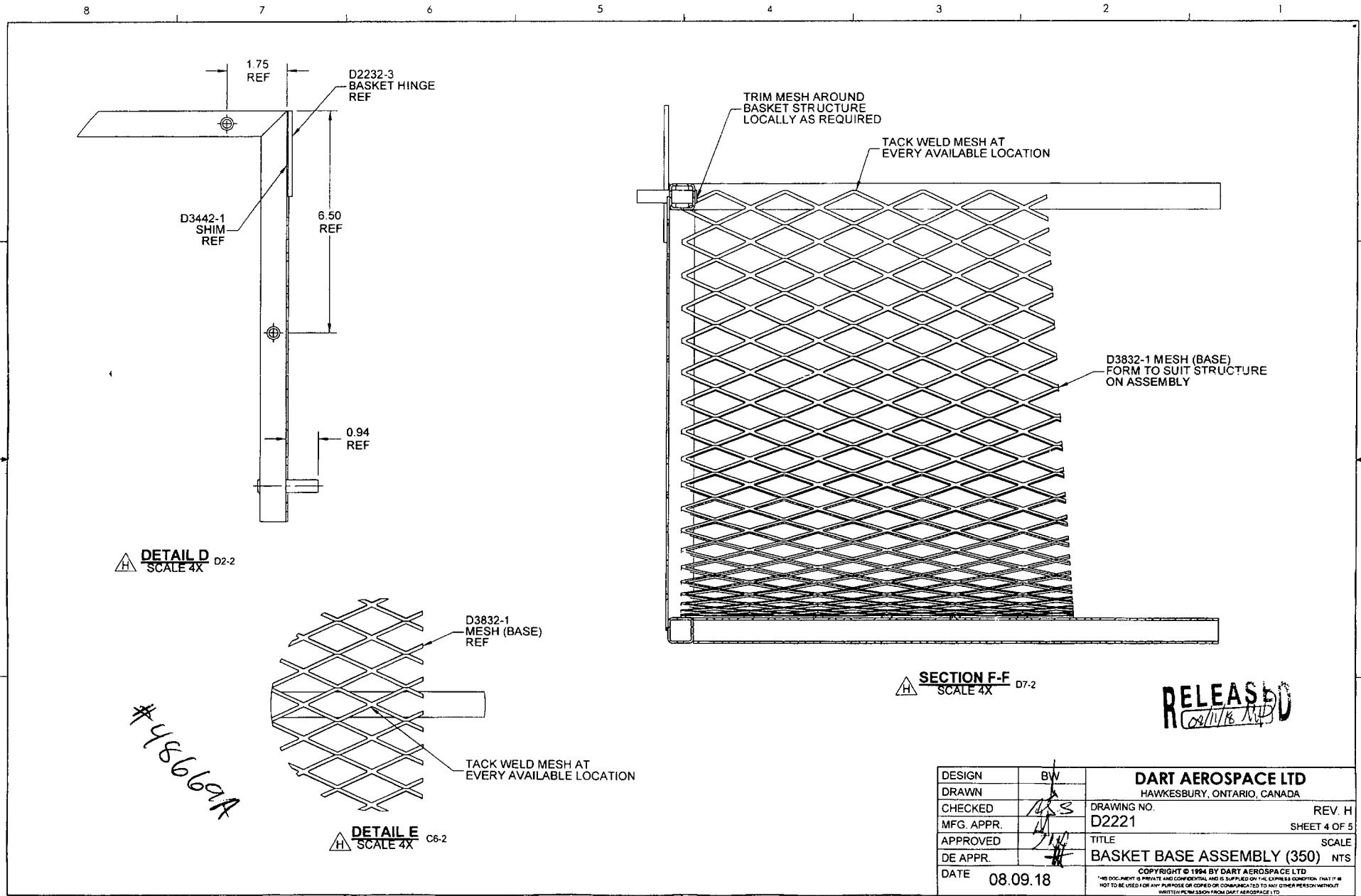
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DESIGN	BW	DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.			
MFG. APPR.		REV. H			
APPROVED		D2221			
DE APPR.		SHEET 4 OF 5			
DATE 08.09.18		TITLE			
BASKET BASE ASSEMBLY (350) NTS		SCALE			
COPYRIGHT © 1994 BY DART AEROSPACE LTD					
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED OR FOR ANY PURPOSE OF COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD					

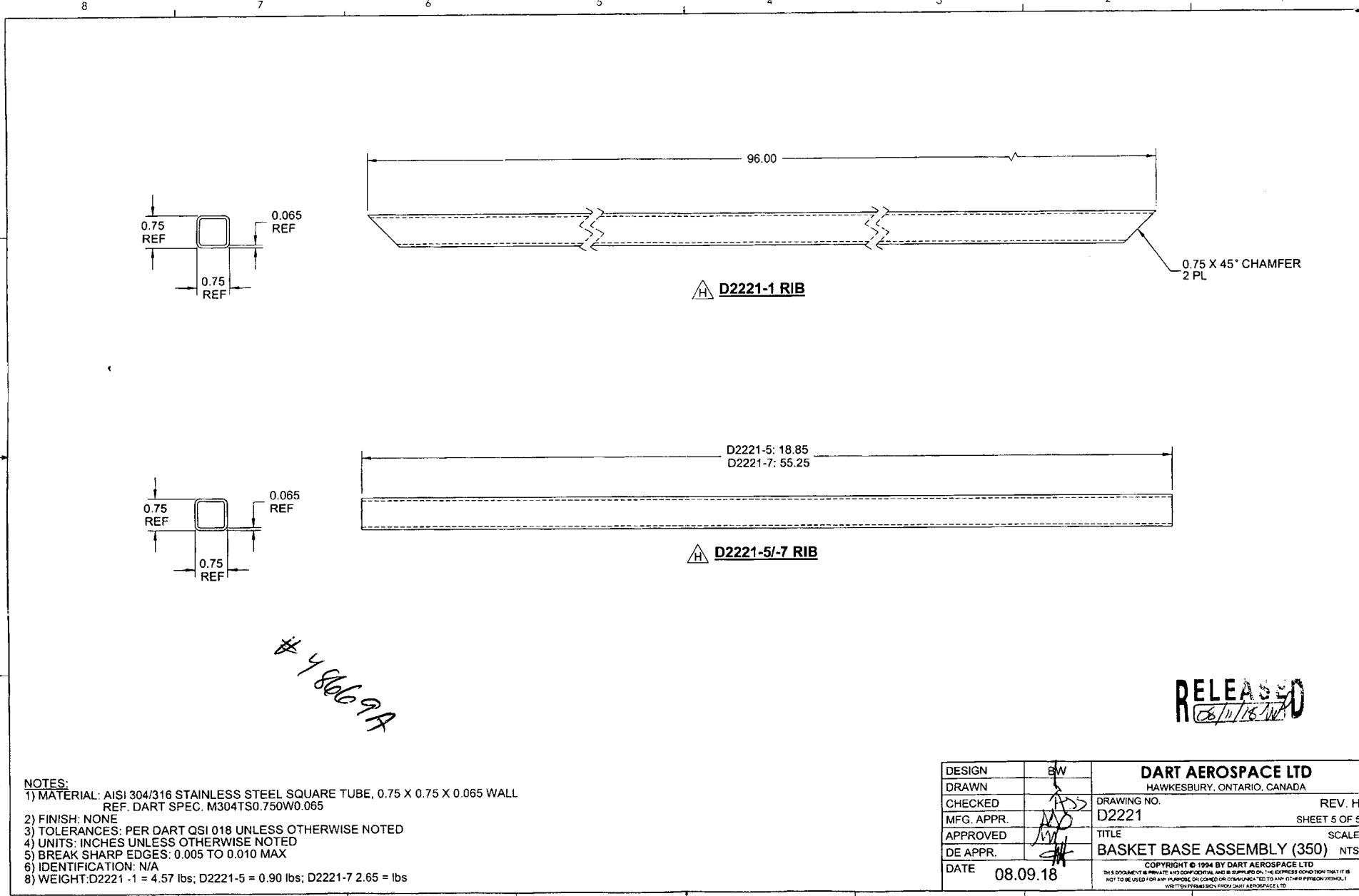
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